IN THE SPECIFICATION

Please amend paragraph 34 of the following paragraph in the specification on page 8 as shown below:

Referring to Figure 8, the carrier assembly 38 includes a plurality of bevel springs 46. The bevel springs are 46 are stacked upon each other to form the biasing force on a shaft 47. The shaft 47 extends upward and forms a portion of the pin 12, core pin 62 or blade pin 92. The springs 46 are biased between the shaft 47 and a spring stop 49. The spring stop 49 is held within the housing 42 by the setscrew 48. The set screw 48 can be adjusted to fine tune the biasing force exerted by the springs 46. The base 44 is mounted to the core clamp plate 30 shown in Figure 1.

Please insert the following paragraphs into the specification on page 9, between paragraphs 34 and 35:

The biasing force exerted by the spring 46 on the shaft 47 balances against molding injection pressures according to a predetermined relationship. The relationship between the biasing force and the molding injection pressures controls the distance that the face 36 of the pin 12 moves relative to the cavity surface. The amount of biasing force provided by the plurality of springs 46 is determined for the specific application mold injection pressures.

The biasing force required for the plurality of springs 46 is determined by first determined the amount of volume loss due to material shrinkage. The amount of volume loss due to material shrinkage is determined by applying a known shrinkage percentage to a known volume. The volume of material within a desired region is determined without regard to material shrinkage according to the relationship:

$$V = \pi * (D/2)^2 * h$$

Where: V= volume of the area;

D= diameter of pin; and

h= height or linear dimension of material.

The height of the molten material within the area of the pin 12 relates to the thickness of the material. This would be consistent throughout if not for the increased shrinkage of material in this region. Accordingly, a shrinkage factor is applied to determine the height loss, or depth of a potential sink mark for the localized area. This is determined by applying a known shrinkage factor as is commonly available from material providers and manufacturers. The shrinkage factor is applied to determine the new height, or loss of height that must be compensated for by the additional molten material. The new height is determined according to the relationship:

$$h_{new} = \frac{V\ shrink}{\pi * (D/2)^2}$$

Where: h new = new height after shrinkage;

D = diameter of the pin; and

Volume after material shrinkage.

The new height is used to determine the loss of height. The loss of height is doubled to obtain the amount of movement required for the pin 12 to receive sufficient amount of molten material to push back up into the mold cavity to compensate for the material shrinkage. The amount of pin movement is then utilized to balance the springs 46 against the injection pressures of the mold. The forces on the pin 12 from injection pressures are determined by the relationship of injection pressures over the area of the face 36 of the pin 12. The springs 46 are then arranged to provide the biasing force that will allow movement of the pin 12 into the passage 34 adjacent the cavity14 to receive the amount of molten material required for preventing deformation caused by material shrinkage.